

August 25, 2015 4:14:11 PM

Order Shipping
Sept 1 for Qty 1 Page 1

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

27
9-89

E

0.00

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type label as per PPP D350-589-011 CHG002

DAS
38
9-89

15-09-03

105

Pick Kit

0.00

Memo

0.00

Packaging

Packaging

~~SECRET~~
27
9-89

DAS
02
9-89

AUG 26 2015

110

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

OC

Quality Control

DAS
38
9-89

15-09-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																										
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OTHER : ☐																																																																														

Work Order ID 135967

August 25, 2015 4:14:11 PM

135967

Page 2

Item ID: D350-589-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Side Door Latch Modification

Stop ***NS2***

Start Date: 8/25/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 9/1/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							DAS 02 9-88
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014 Location :FG022								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.01							
Quality Control									

SEP 02 2015

15/9/34

SLL 20150903

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

August 25, 2015 4:14:21 PM

135967

D350-589-011

Required Date: 9/1/2015

Required Qty: 5.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2237		Manufactured	No			105	Each	20.0000	3	15			
D2237	DAS 38 9-89								**				
Striker Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 27 9-89	DAS 02 9-89
				ST005		20							
				121746		2				15			
				128358		18							
D2583		Manufactured	No			105	Each	0.0000	3	15			
D2583	DAS 38 9-89								**				
Latch Bracket								B13SS77		15		DAS 27 9-89	DAS 02 9-89
D2585		Manufactured	No			105	Each	16.0000	3	15			
D2585	DAS 38 9-89								**				
Latch Clamp													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 27 9-89	DAS 02 9-89
				ST008		16							
				127709		2				11			
				130053		11							
				132766		3							

AUG 26 2015

AUG 26 2015

B135617

Picklist Print

August 25, 2015 4:14:21 PM

Page 2

Work Order ID: 135967

135967

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/25/2015

Required Date: 9/1/2015

Start Qty: 5.00

Required Qty: 5.00

D2586

Manufactured No

105

Each

19.0000

3

15

D2586

DAS
38
9-89

Door Latch

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

14

100607

1

B135943

114985

5

119746

4

83893

3

B135416

95760

1

ST482

3

129404

3

ST484

2

134338

2

D2587

Manufactured No

105

Each

6.0000

1

5

D2587

DAS
38
9-89

Door Plug

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST008

6

132626

6

D2589

Manufactured No

105

Each

24.0000

1

5

D2589

DAS
38
9-89

Keys, Key Chain

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST008

24

132942

24

AUG 26 2015

Picklist Print

August 25, 2015 4:14:21 PM

Page 3

Work Order ID: 135967

135967

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/25/2015

Required Date: 9/1/2015

Start Qty: 5.00

Required Qty: 5.00

MS20470AD4-5

Purchased

No

105

Each

844.0000

6

30

MS20470AD4-5

DAS
38
9-89

RIVET, UNIVERSAL HEAD

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

781

m128401

757

m128813

24

ST310

63

m128401

42

m128813

21

MS21042L3

Purchased

No

105

Each

1,250.000

3

15

MS21042L3

DAS
38
9-89

Nut

DAS
27
9-89
AUG 26 2015

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

237

M131317

237

ST305

629

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

47

~~M132020~~

500

Picklist Print

August 25, 2015 4:14:22 PM

Page 4

Work Order ID: 135967

135967

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/25/2015

Required Date: 9/1/2015

Start Qty: 5.00

Required Qty: 5.00

MS27039-1-15

Purchased

No

105

Each

936.0000

3

15

MS27039-1-15

Screw

DAS
38
9-89

Location

Loc Qty

Loc Code

GA

55

m127916

55

ST273A

800

m132640

600

m132701

200

ST285

81

m127916

10

m130388

1

m132317

70

DAS
27
9-89

DAS
02
9-89

NAS1149D0363J

Purchased

No

105

Each

1,936.000

3

15

NAS1149D0363.J

Washer

DAS
38
9-89

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

302

m130799

302

ST269

1388

m126319

7

m131618

1

m132317

108

m132677

272

m133031

1000

DAS
27
9-89
AUG 28 2015
DAS
02
9-89

Work Order ID 135967

August 25, 2015 4:14:11 PM

135967

Order Shipping
Sept 1 for Qty' Page 1

Item ID: D350-589-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Side Door Latch Modification
 Start Date: 8/25/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 9/1/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 20150825 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

MLS AUG 27 2015

AUG 26 2015

3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.